

Date: Thursday, 2/7/2008 10:52:29 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 37277	
Estimate Number : 12729	
P.O. Number :	Part Number : D353539
This Issue : 2/7/2008 S.O. No. :	Drawing Number : D3535 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 35257	Material :
Written By : <u>JD 080207</u>	Due Date : 2/27/2008 Qty: 16 Um: Each
Checked & Approved By : <u>JD 080207</u>	
Comment : Est Rev:A New Issue 07-02-15 JLM	
Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.9986 sf(s)/Unit Total : 15.9768 sf(s)
 304/316 .040 Sheet
 (M304S20GA)
 Batch: 106748 IB 8-2-12

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3535
 Dwg Rev: B IB 8-2-12
 Prog Rev: B

2-Deburr if necessary IB 8-2-12

(16)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5 08/02/2016 (16)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Deburr if necessary
 Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.
 Identify as D3535-41
 Form Joggle on brake using Jig DT8158 as per Dwg D3535

08/02/2016 (16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 28/02/22

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/7/2008 10:52:29 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 37277

Part Number: D353539

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



08-02-20 (16)



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



M106442



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

08-02-20 (16)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BL 08-02-20 (16)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *EP-17*

BL 08-02-20 (16)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AD 08/02/20 (16)

Job Completion



mi 2008/2/20 (16)
W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	37277
Description: Wearshoe		Part Number:	D3535-39
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.815	+/-0.010	36.815	x			
32.775	+/-0.010	32.775	x			
29.275	+/-0.010	29.275	x			
25.775	+/-0.010	25.775	x			
23.250	+/-0.010	23.250	x			
19.750	+/-0.010	19.750	x			
17.750	+/-0.010	17.750	x			
14.250	+/-0.010	14.250	x			
9.500	+/-0.010	9.500	x			
4.750	+/-0.010	4.750	x			
2.000	+/-0.010	2.000	x			
5.00	+/-0.030	5.00	x			
9.00	+/-0.030	9.00	x			
28.00	+/-0.030	28.00	x			
Ø0.188	+0.005/-0.001	.191	x			
1.885	+/-0.010	1.885	x			
0.300	+/-0.010	.303	x			
0.300	+/-0.010	.303	x			
0.038	+/-0.010	.035	x			

Measured by:	LB
Date:	8-2-12

Audited by:	J
Date:	08/02/12

Prototype Approval:	N/A
Date:	N/A

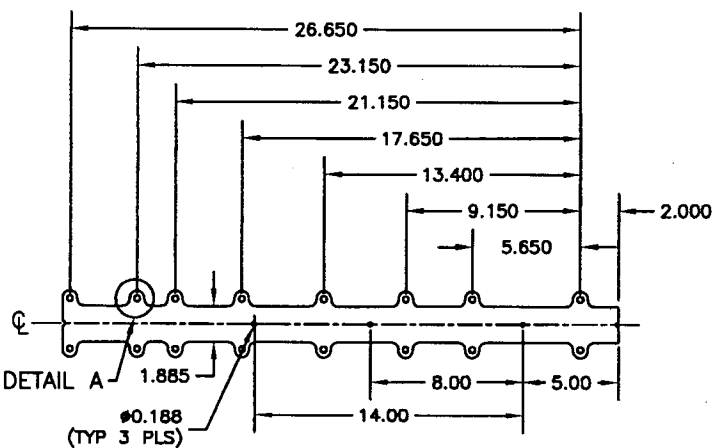
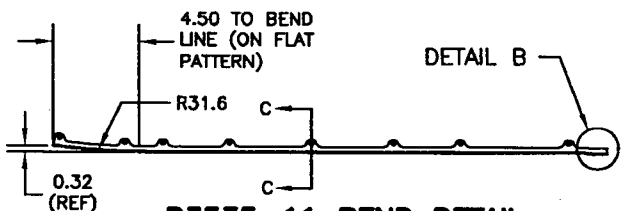
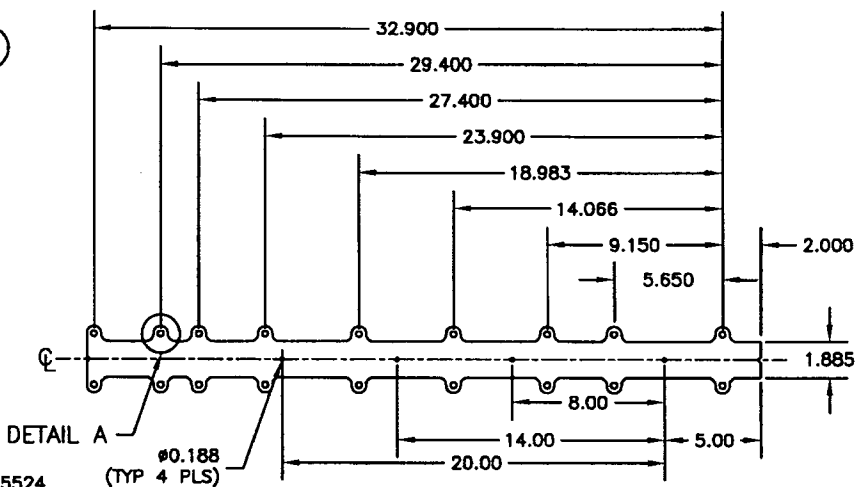
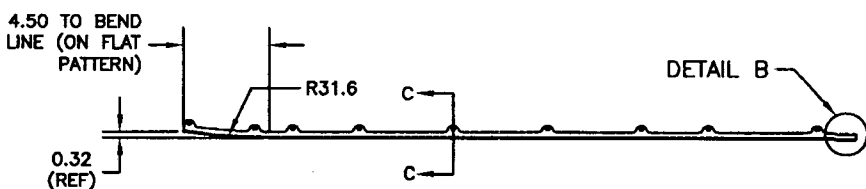
Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	BE

DART

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07.04.24



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
CB	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
<i>[Signature]</i>	<i>[Signature]</i>	D3535	SHEET 1 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		

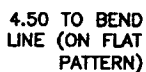
**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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DATE 07.04.17		TITLE WEARSHOE	SHEET 2 OF 7 SCALE 1:10



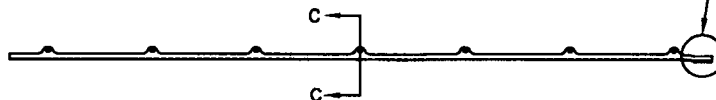
DETAIL B -



NOTES

-
- Technical drawing of a bridge deck cross-section. The drawing shows a series of vertical reinforcement bars (piles) and horizontal reinforcement bars (AMS 5524). Dimensions are provided in feet and inches. Key dimensions include:
- Overall width: 32.700
 - Distance from centerline to first pile: 27.250
 - Distance between piles: 21.800, 16.350, 10.900, 5.450
 - Distance from centerline to last pile: 2.000
 - Distance from centerline to first horizontal bar: 6.00
 - Distance between horizontal bars: 8.00, 16.00, 24.00
 - Distance from centerline to last horizontal bar: 1.885
 - Reinforcement bar size: #0.188 (TYP 4 PLS)
 - Reinforcement bar type: AMS 5524
 - Detail A: A circular detail showing a cross-section of a pile.

- DETAIL B



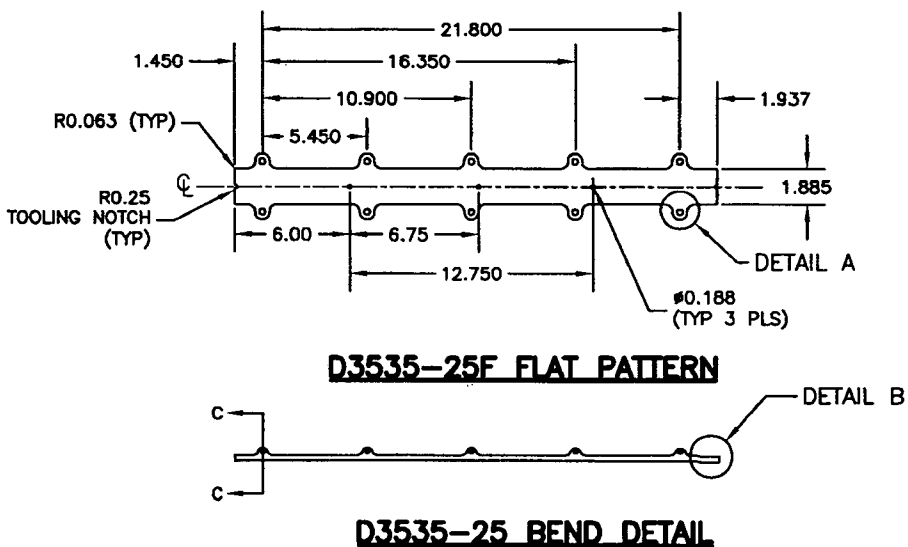
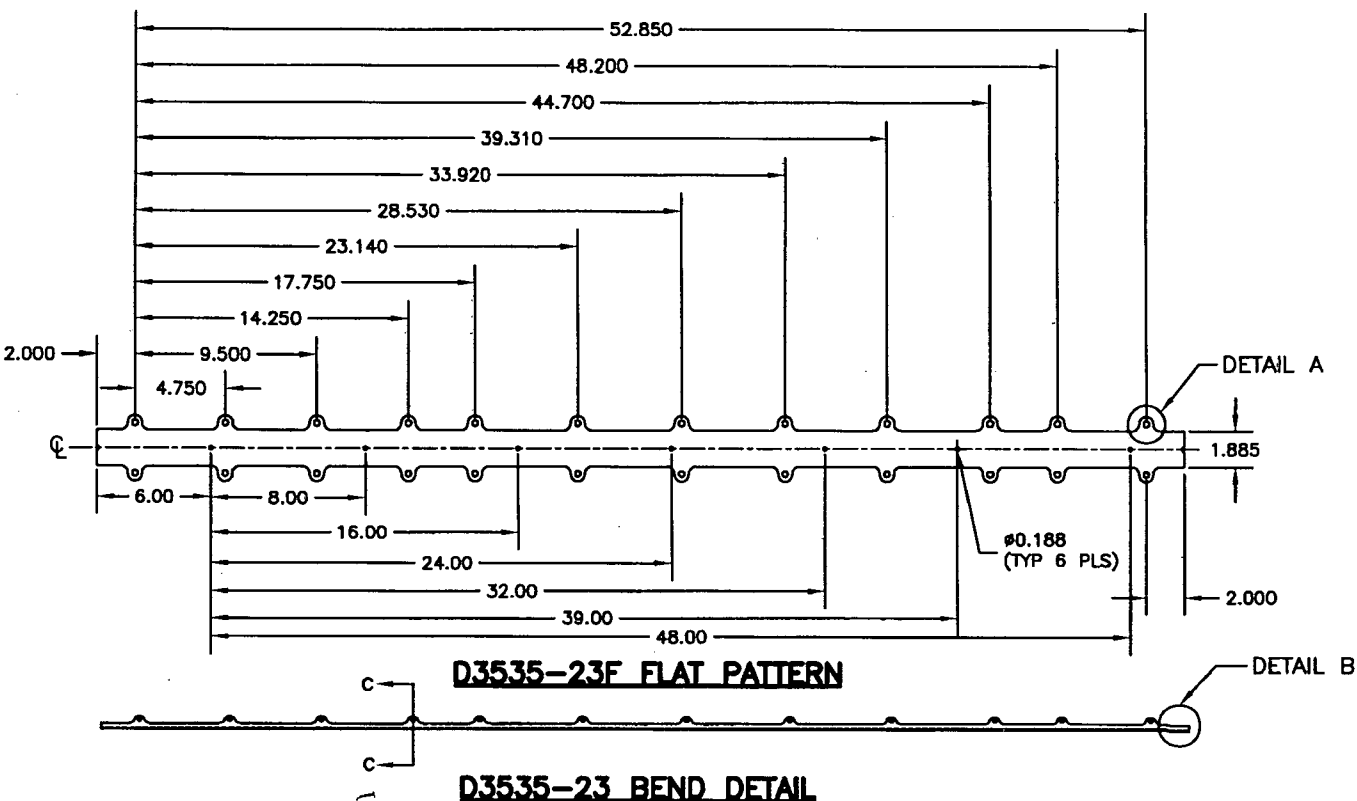
D3535-21 BEND DETAIL

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		TITLE	WEARSHOE	SHEET 3 OF 7
		SCALE	1:10	



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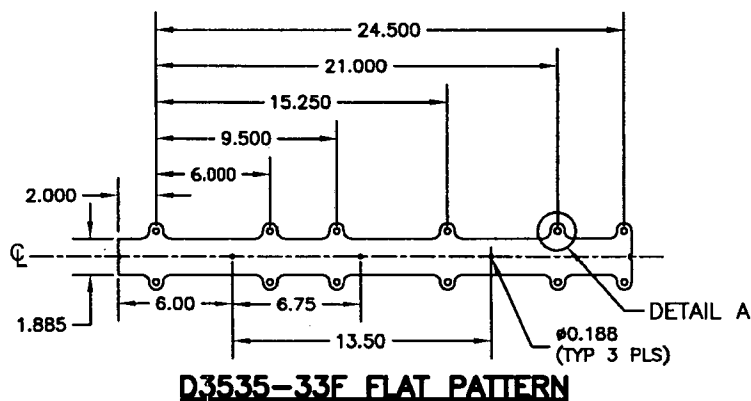
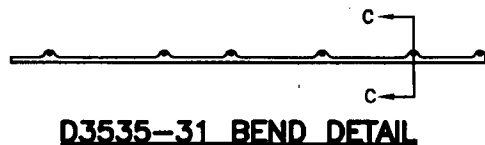
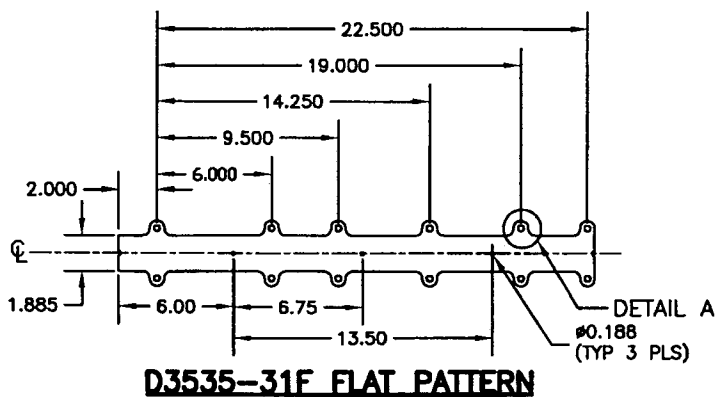
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		TITLE	WEARSHOE	SCALE	1:10

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NOTES

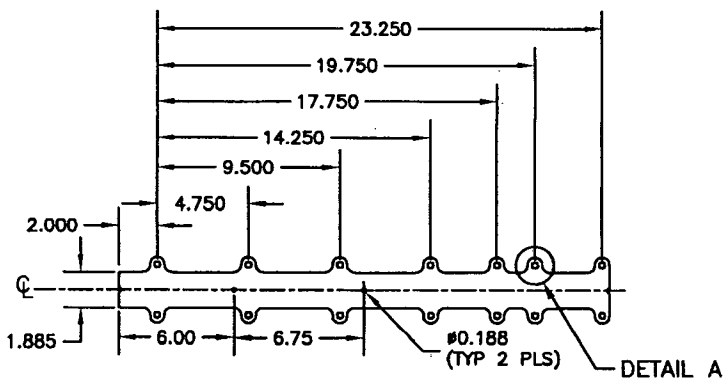
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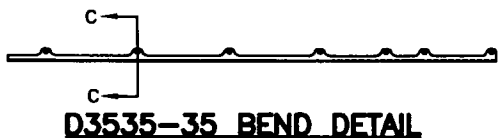
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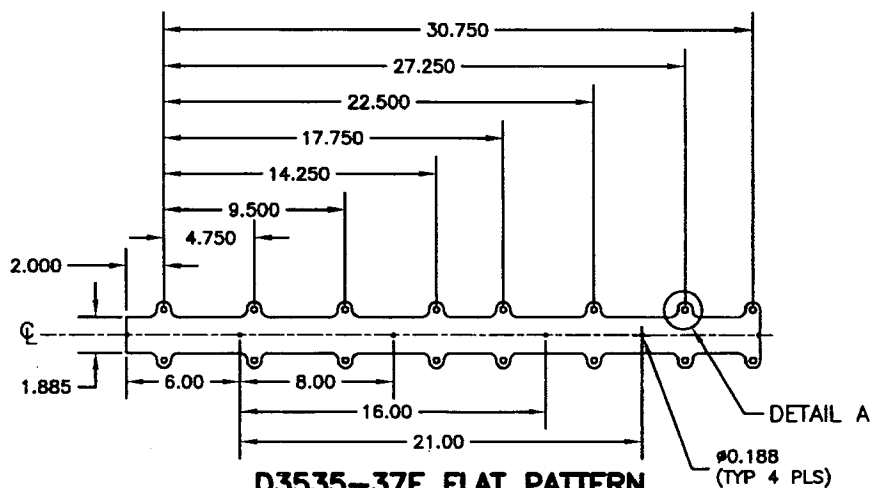
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		TITLE	WEARSHOE	SHEET 5 OF 7
		SCALE	1:10	



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

NOTES

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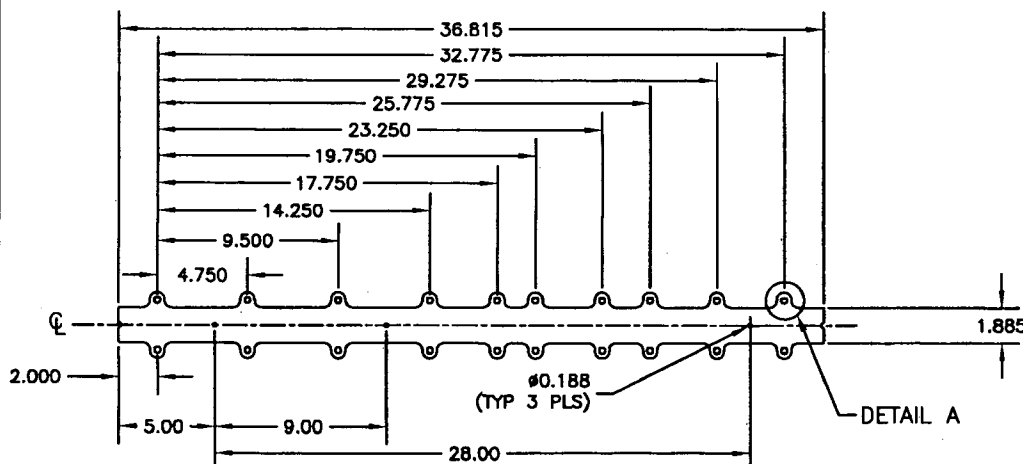
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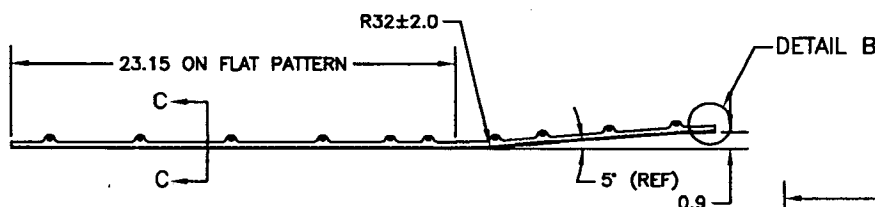
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		SCALE	1:10	

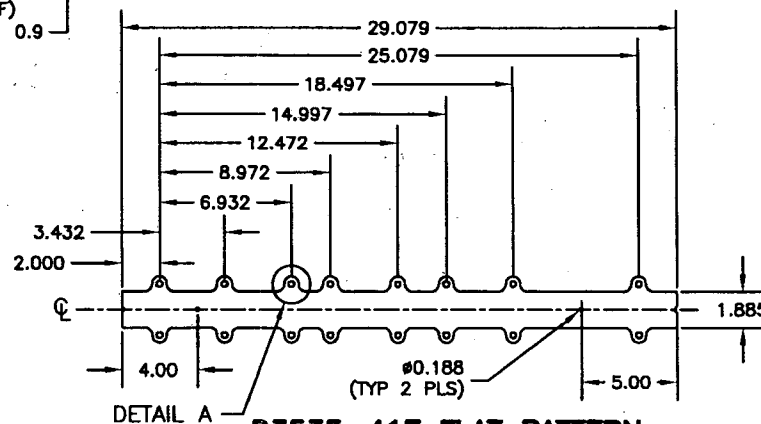


D3535-39F FLAT PATTERN

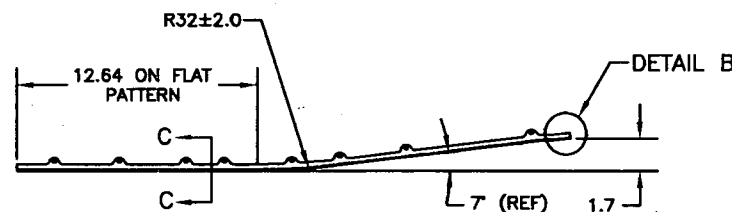


D3535-39 BEND DETAIL

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D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

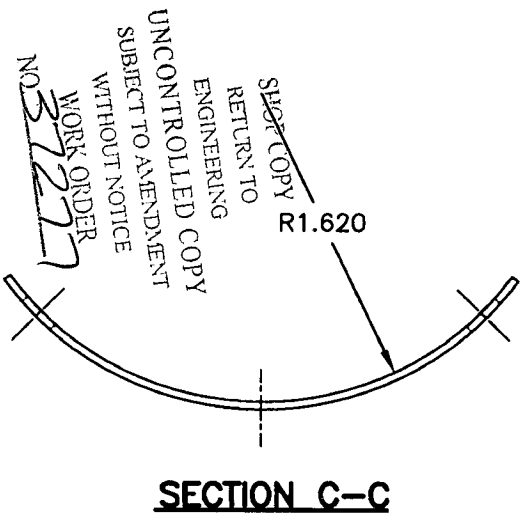
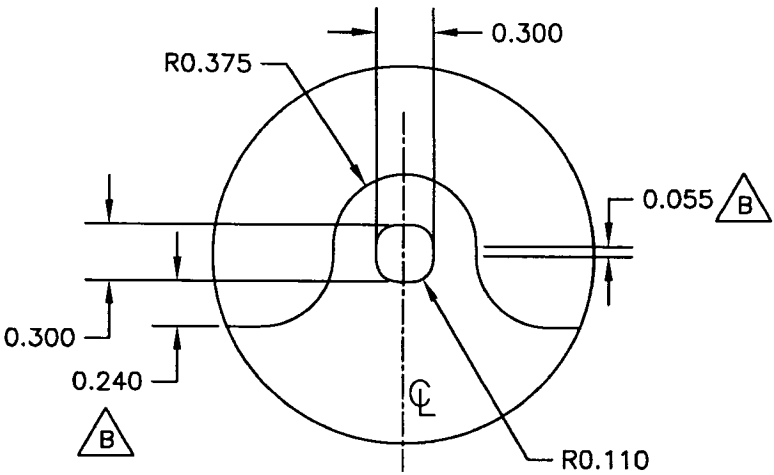
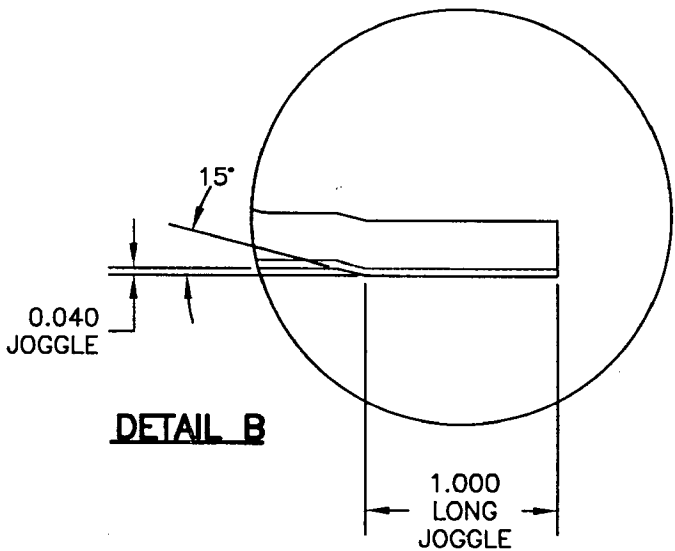
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DATE	07.04.17			SHEET 7 OF 7
				SCALE 1:1
				TITLE WEARSHOE

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